Slip 12/06

Dart Aerospace Ltd.

Date: Thursday, 05/06/2008 1:50:24 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 39733
Estimate Number : 11282
P.O. Number :
This Issue : 05/06/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : LARGE FAB ASSY
Previous Run : 34669
Written By :
Checked & Approved By :
Comment : Est Rev:I Revised as per Rev I 05-12-07 JLM
Est Rev:J reformat 06.04.04 EC
Est Rev:K 07-03-20 As per DSI9361 JLM

Drawing Name : 206B UTILITY BASKET
Part Number : D206540013
Drawing Number : D206-540 REV I
Project Number : N/A
Drawing Revision : I
Material :
Due Date : 12/06/2008 **Qty:** 1 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPPD206-540-013 CHG005 S 08/04/12

2.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Assemby Kit

3.0	39733A	206B BASKET LID - UNDER REVIEW

Not in comp yet

Comment: Sub-Component 206B BASKET LID
1 x D2330-043 Batch 39733A SP

4.0	39733B	206B BASKET BASE - UNDER REVIEW

Not in comp yet

Comment: Sub-Component 206B BASKET BASE
1 x D2330-041 Batch 39733B SP

5.0	D2332041	Lid Prop Assembly 6.69" long

1x

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	D2332-041	Prop Ass'y	38597

8/6/6 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Thursday, 05/06/2008 1:50:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206B UTILITY BASKET

Job Number: 39733 **Part Number:** D206540013

Job Number:

M107939
2X
MS21042L5

Seq. #:	Machine Or Operation:	
6.0	D2022101	Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2022-101 SPACER 33985

SQ

7.0	D2530	Handle Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2530 Handle Weldment 37853

SQ

8.0	D2535	Spring

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2535 Spring 37071

SQ

9.0	D2537	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2537 Bushing 37605

SO

10.0	D2931	Bumper

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4. D2931 Bumper 21139

SQ

11.0	MS20600AD4W3	Cherry Rivets

(1x)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS20600AD4W3 Rivet 18071

8/6/6 SQ

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 1:50:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206B UTILITY BASKET

Job Number: 39733 **Part Number:** D206540013

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	AN47A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN4-7A Bolt 107321 SP

Seq. #:	Machine Or Operation:	Description :
13.0	AN424A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 AN4-24A Bolt 104547 SP

Seq. #:	Machine Or Operation:	Description :
14.0	AN316A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN3-16A Bolt 106815 SP

Seq. #:	Machine Or Operation:	Description :
15.0	D27283	Dart Logo Label - large

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Dart Logo label large
Batch: ~~106815~~ 22553 SP

Seq. #:	Machine Or Operation:	Description :
16.0	AN422A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 AN4-22A Bolt 104937 SP

Seq. #:	Machine Or Operation:	Description :
17.0	AN517A	Bolt

(X)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN5-17A Bolt 106815 8/6/6 SO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 1:50:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206B UTILITY BASKET

Job Number: 39733 **Part Number:** D206540013

Job Number:

Seq. #:	Machine Or Operation:	Description :
18.0	AN960JD416	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD416 Washer 102929 SP

Seq. #:	Machine Or Operation:	Description :
19.0	AN960JD416L	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer 107008 SP

Seq. #:	Machine Or Operation:	Description :
20.0	AN960JD516	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD516 Washer 107534 SP

Seq. #:	Machine Or Operation:	Description :
21.0	AN9704	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN970-4 Washer 107715 SP

Seq. #:	Machine Or Operation:	Description :
22.0	AN960JD8	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD8 Washer 101091 SP

Seq. #:	Machine Or Operation:	Description :
23.0	MS21042L3	Nut

(?)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) 107644 8/6/6 SP

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 1:50:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206B UTILITY BASKET

Job Number: 39733 **Part Number:** D206540013

Job Number:

Seq. #:	Machine Or Operation:	Description :
24.0	MS21042L4	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L4 Nut (or -4) 103914

SP (1x) (PD)

Seq. #:	Machine Or Operation:	Description :
25.0	D2258170	Label - 170 lb

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2258-170 Placard 16266 8/6/6 SP

Seq. #:	Machine Or Operation:	Description :
26.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D206-540 08/06/11

Seq. #:	Machine Or Operation:	Description :
27.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 08/06/10

Seq. #:	Machine Or Operation:	Description :
28.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Packing Kit

Seq. #:	Machine Or Operation:	Description :
29.0	D2249041	Fitting Assembly

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 D2249-041 Braket 34671

SP

Seq. #:	Machine Or Operation:	Description :
30.0	MS21042L5	Nut

(1x)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L5 Nut (or -5) 107464 8/6/6 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-540-013 PAR #: N/A Fault Category: Prod / Par med/small NCR: (Yes) No DQA: D Date: 08/06/12

QA: N/C Closed: [signature] Date: 08/06/13

NCR: 39733		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Corrective Action Section B: Action Description Chief Eng	Corrective Action Section B: Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
08.06.12	27.0	During inspection it was noticed that the wrong weight table (placard) was installed on the deck plate it read 160lbs not 170.	[signature] 08.06.12	- remove the 160 label and place the proper label on 170'	[initials] 08/06/11	[signature] 08-06-11	[signature] 08.06.12	[signature] 08-06-11
		i.e. A 160lbs was placed in the 170lbs box.						

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 1:50:24 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206B UTILITY BASKET

Job Number: 39733 **Part Number:** D206540013

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	D33963	Spacer
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Spacer Batch: 34741	SP
32.0	D2022101	Spacer
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Packing Kit 4 D2022-101 Spacer 33985	SP
33.0	D2012107	Clevis
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 D2012-107 Clevis 33585	SP
34.0	D2259	Label
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 D2259 Placard 10671	SP
35.0	D2525	Spacer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2525 Spacer kit 34506	SP
36.0	D2526	Bushing
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2526 Bushing 27555	SP
37.0	D2748	Clevis
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2748 Clevis 27560 8/6/4	SP

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 1:50:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206B UTILITY BASKET

Job Number: 39733 **Part Number:** D206540013

Job Number:

Seq. #:	Machine Or Operation:	Description :
38.0	D27491	Strut
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 D2749-1 Strut 23423	S
39.0	D27493	Strut
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 D2749-3 Strut 23424	S
40.0	D2814	Strut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2814 Strut 25296	S
41.0	AN412A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 2 AN4-12A Bolt 13654	S
42.0	AN412	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 AN4-12 Bolt 104016	S
43.0	AN45A	Bolt
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Packing Kit 8 AN4-5A Bolt 106242	7x 8/6/6 S

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 1:50:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206B UTILITY BASKET

Job Number: 39733 **Part Number:** D206540013

Job Number:

Seq. #:	Machine Or Operation:	Description :
44.0	AN517A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 AN5-17A Bolt 106815	SP
45.0	AN421A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 AN4-21A Bolt 11695	SP
46.0	AN960JD416	Washer
	Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 19 AN960JD416 Washer 102929	SP
47.0	AN960JD516	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 AN960JD516 Washer 107534	SP
48.0	AN9704	Washer
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 AN970-4 Washer 107715	SP
49.0	MS21042L4	Nut
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 4 MS21042L4 Nut (or -4) 104683	1x 8/6/6 SD

 Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 1:50:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206B UTILITY BASKET

Job Number: 39733 **Part Number:** D206540013

Job Number:

Seq. #:	Machine Or Operation:	Description :
50.0	MS21042L5	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 MS21042L5 Nut 101464
SY

Seq. #:	Machine Or Operation:	Description :
51.0	MS27039411	Screw

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
1 MS27039-4-11 Screw 3355
SY

Seq. #:	Machine Or Operation:	Description :
52.0	AN46	Bolts

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
1 AN4-6 Bolt 9599
SY

Seq. #:	Machine Or Operation:	Description :
53.0	AN3204	Nut

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Pick: Packing Kit
3 AN320-4 Nut 7195
SY

Seq. #:	Machine Or Operation:	Description :
54.0	AN38022	Cotter Pins

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Pick: Packing Kit
3 AN380-2-2 Cotter pin 16895 8/6/6 SY

Seq. #:	Machine Or Operation:	Description :
55.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS 08/06/12

Seq. #:	Machine Or Operation:	Description :
56.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D206-540-013
Location: A
PPP Rev: A

8/6/12

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 1:50:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206B UTILITY BASKET

Job Number: 39733 **Part Number:** D206540013

Job Number:

Seq. #:	Machine Or Operation:	Description :
57.0	QC21	FINAL INSPECTION/W/O RELEASE

08/06/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

4 08-06-12

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date.& initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	MB	
CHECKED	APPROVED	DRAWING NO. D206-540 REV. I SHEET 1 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION SCALE NTS

Rev	Date	Description
C	94.07.28	REVISED DRAWING
D	94.11.12	ADDED D2323 STRUT
E	94.11.12	CHANGED SECTION C-C
F	94.11.12	ADDED HANDLE AND LID PROP
G	99.09.21	REDRAW, CHANGE LATCH/HINGE/STRUTS
H	99.12.02	INCORPORATE DSI 9174 / DEO 9167
I	05.11.10	REPLACED PIANO HINGE SYSTEM

Qty -011	Qty -013	Part No.	Description
X		D206-540-011	**BASKET INSTL'N - BELL 206L/L1/L3/L4**
	X	D206-540-013	**BASKET INSTL'N - BELL 206A/B**
	1	D2012-107	CLEVIS
2	6	D2022-101	SPACER
2	2	D2249-041	BRACKET
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	D2258-170	PLACARD
1	1	D2259	PLACARD*
	1	D2330-041	BASKET ASSEMBLY
	1	D2330-043	LID ASSEMBLY
1	1	D2332-041	LID PROP ASSEMBLY
2	2	D2525	SPACER KIT
2	2	D2526	BUSHING
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2	D2748	CLEVIS
	1	D2749-1	STRUT
	1	D2749-3	STRUT
1		D2749-5	STRUT
1		D2749-7	STRUT
	2	D2814	STRUT
4	4	D2931	BUMPER
2	2	AN3-16A	BOLT
	3	AN320-4	NUT
	3	AN380-2-2	COTTER PIN
	2	AN4-12	BOLT
2	2	AN4-12A	BOLT
2	2	AN4-21A	BOLT
1	1	AN4-22A	BOLT
1	1	AN4-24A	BOLT
8	8	AN4-5A	BOLT
	1	AN4-6	BOLT
2	2	AN4-7A	BOLT
6	6	AN5-17A	BOLT
16	23	AN960JD416	WASHER
6	6	AN960JD516	WASHER
4	4	AN960JD8	WASHER
4	5	AN970-4	WASHER
4	4	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
8	8	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
	1	MS27039-4-11	SCREW

*NOTE: Placard D2259 to be installed in cock pit near the airspeed indicator.

W/O 39733

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D206-540 REV. I SHEET 2 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION SCALE NTS

WEIGHT AND BALANCE

		LATERAL		LONGITUDINAL	
Installation	**Weight**	**Arm**	**Moment**	**Arm**	**Moment**
D206-540-011 206 L Series Basket Installation	70 lb 31.8 kg	40.0 in 1.0 m	2800 in-lb 31.8 m-kg	111.0 in 2.8 m	7770 in-lb 89.0 m-kg
D206-540-013 206 A/B Series Basket Installation	50 lb 22.7 kg	40.0 in 1.0 m	2000 in-lb 22.7 m-kg	99.0 in 2.5 m	4950 in-lb 56.8 m-kg

GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer.** Ensure that this installation does not conflict with a previous modification. This basket can only be installed on the starboard side of the aircraft on high gear. Ensure that any steps that are outboard of the crosstubes are removed.

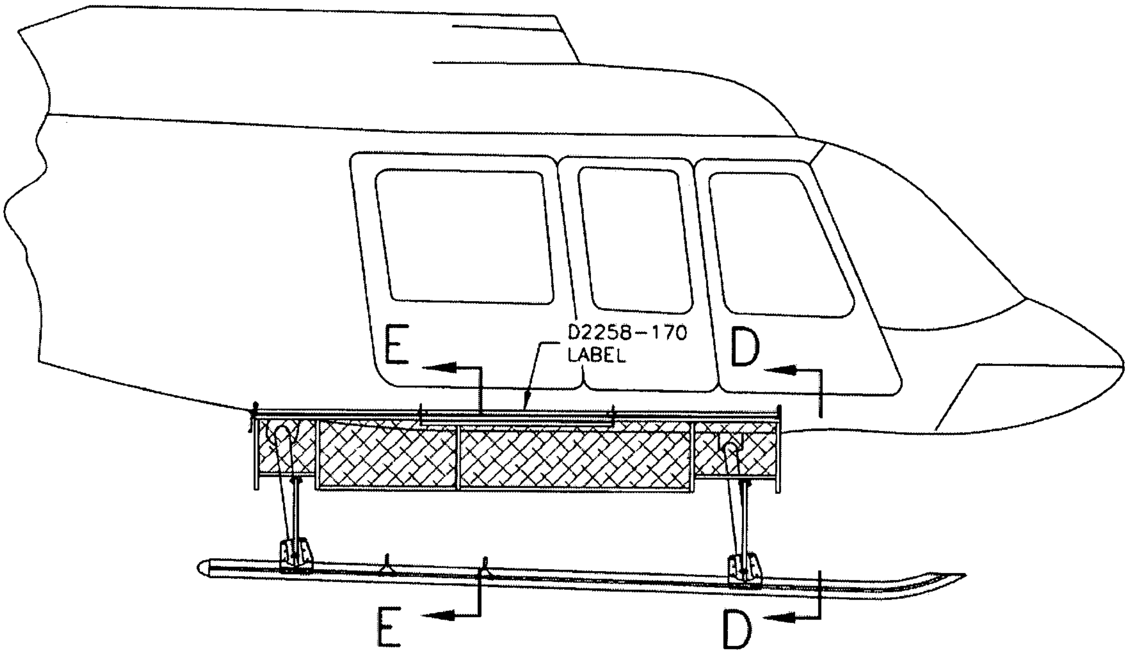
WORKMANSHIP

Unless otherwise stated, all workmanship should be to the standard set by the Aircraft Maintenance Manual.

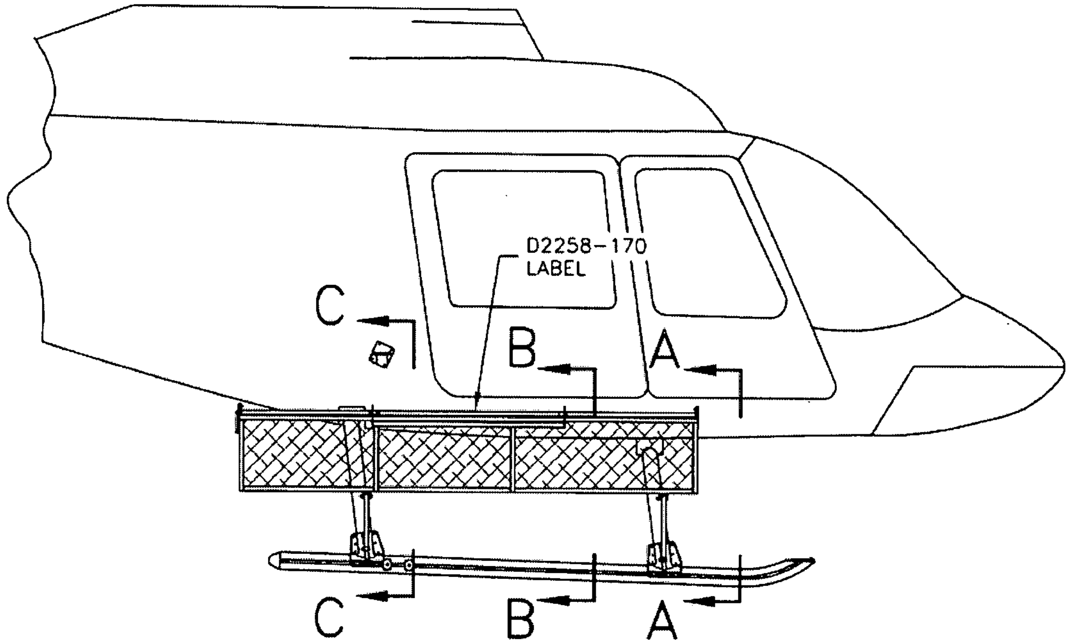
CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Maintenance Manual Supplement **MMS-D206-540**.

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
KE	MB		
CHECKED	APPROVED	DRAWING NO. D206-540	REV. 1 SHEET 3 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS



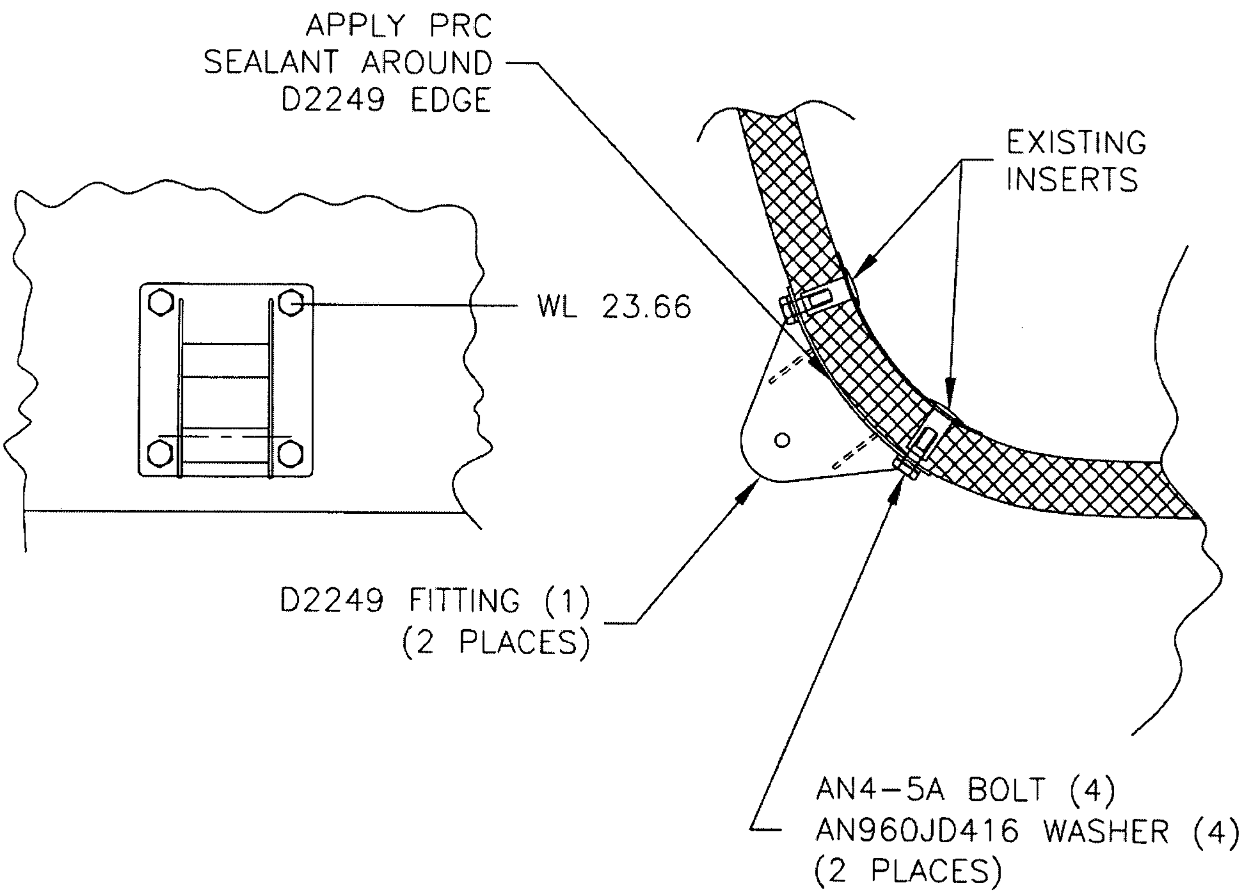
D206-540-011 206L/L1/L3/L4 BASKET INSTALLATION



D206-540-013 206A/B BASKET INSTALLATION

DART

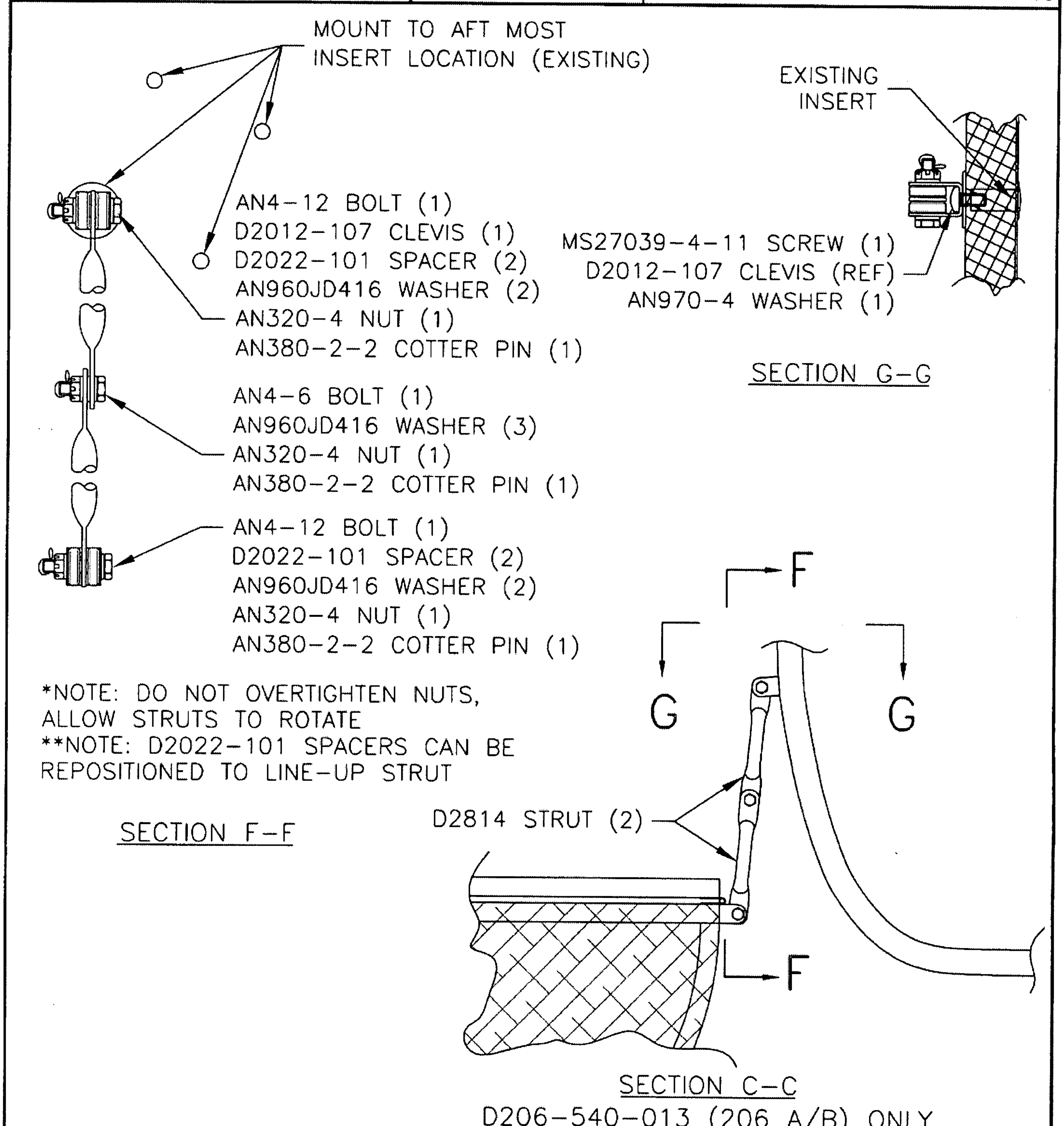
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	MB	
CHECKED	APPROVED	DRAWING NO. D206-540 — REV. I — SHEET 4 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION — SCALE NTS

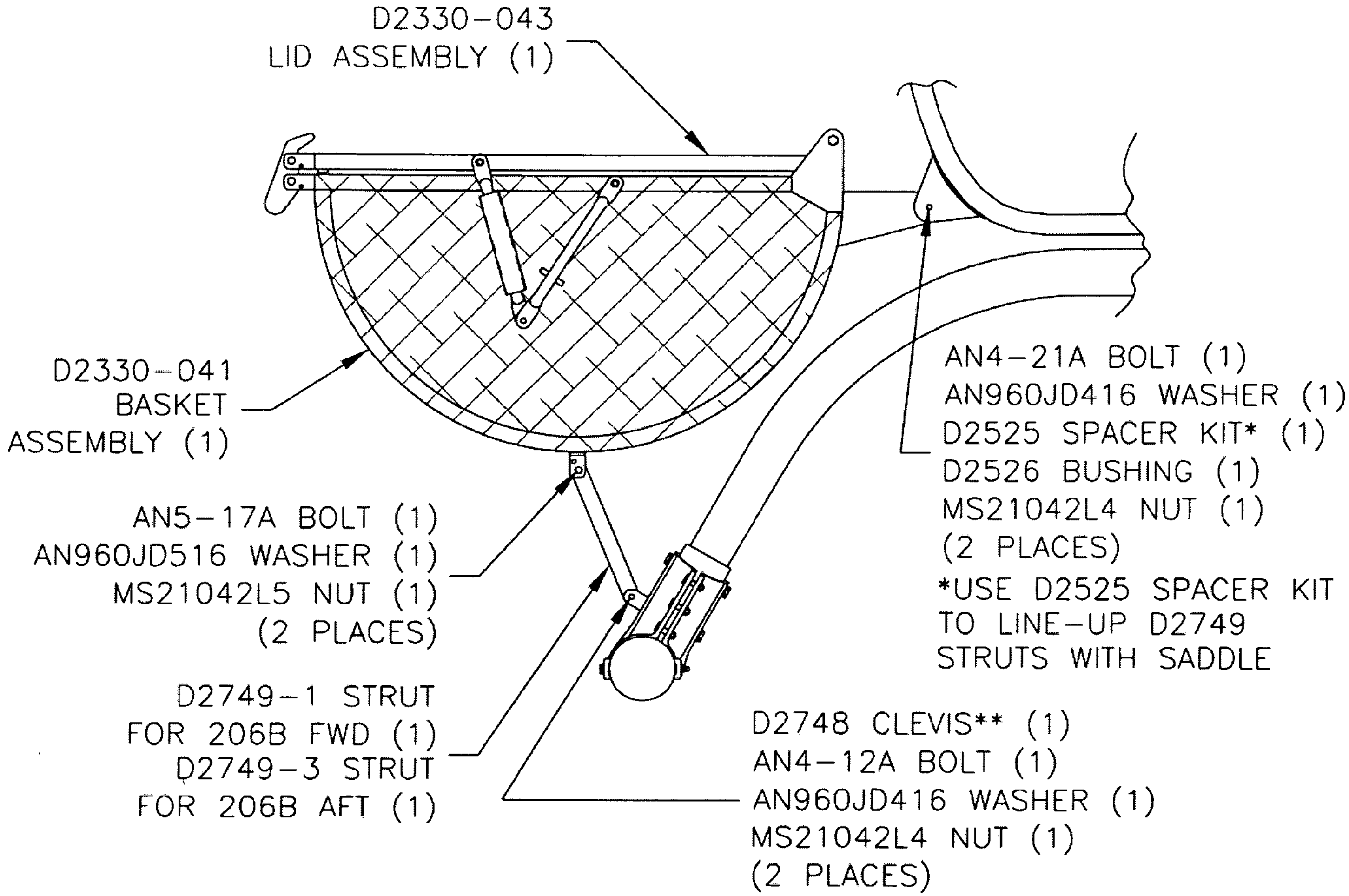


BRACKET DETAIL
REPLACE 206-031-370-6
AND 206-031-370-8 STEPS AS
REQUIRED WITH D2249 FITTINGS.
REFER TO SERVICE INSTRUCTION
BHT-206-SI-22

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D206-540 — REV. I — SHEET 5 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION — SCALE NTS





**NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748 CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

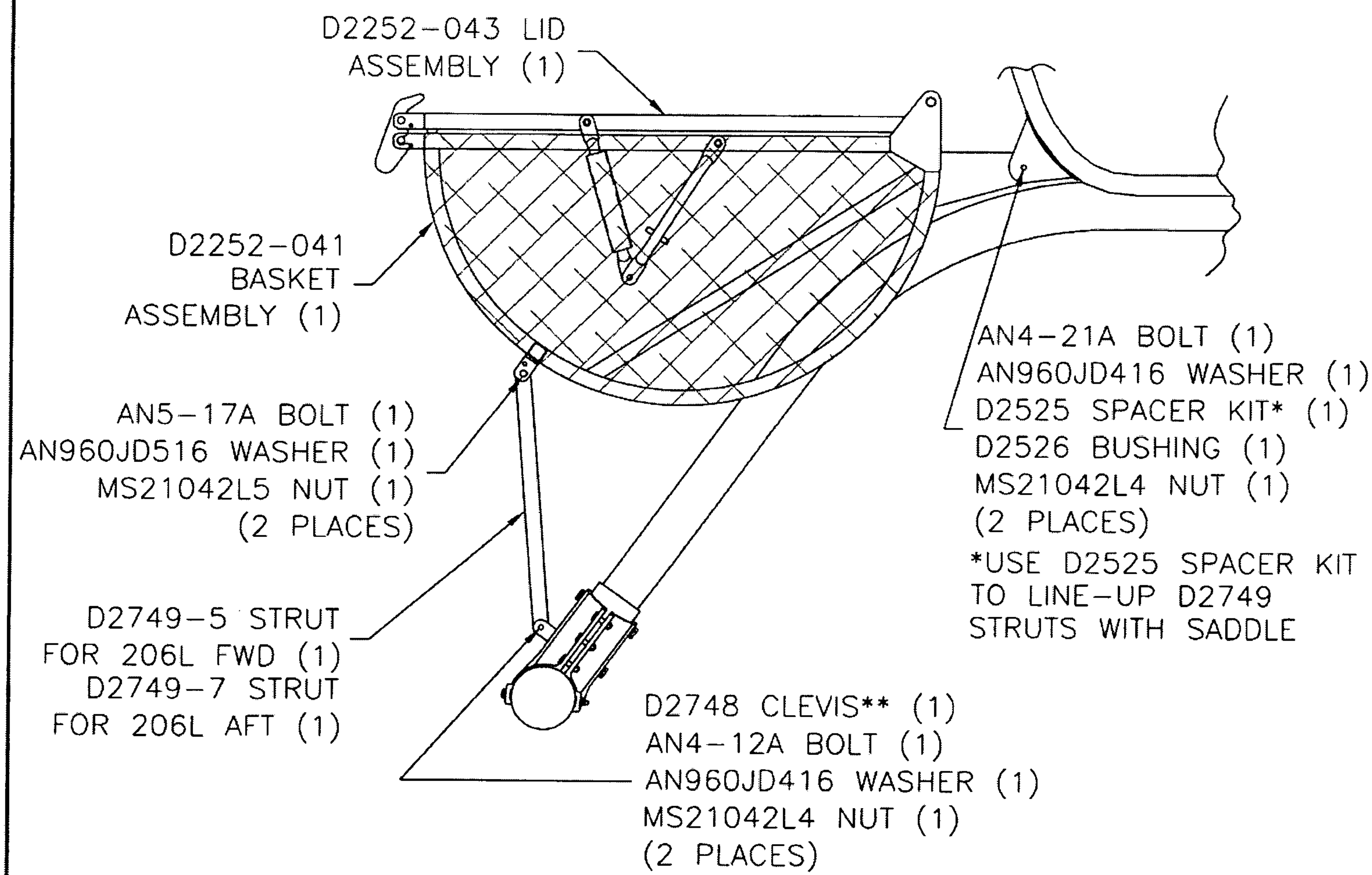
SECTION A-A AND B-B

D206-540-013 (206 A/B) ONLY

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY
KE	MB
CHECKED	APPROVED
DATE: 05.11.10	DRAWING NO. D206-540 REV. 1
TITLE: UTILITY BASKET INSTALLATION	SHEET 6 OF 8
SCALE: NTS	



**NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748 CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

SECTION D-D AND E-E

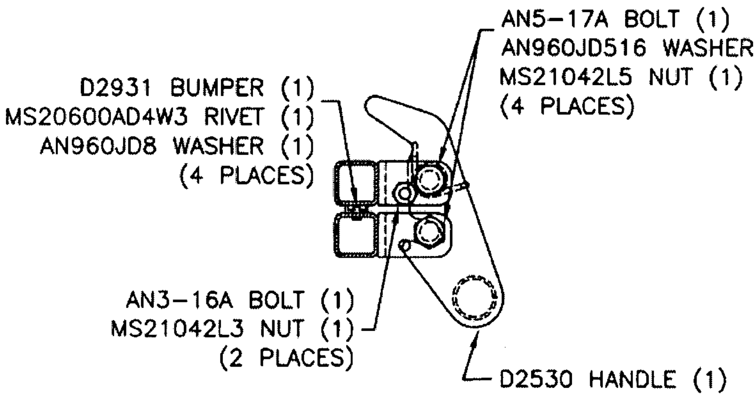
D206-540-011 (206 L/L1/L3/L4) ONLY

DART

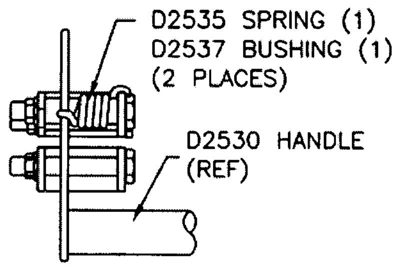
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
KE	MB	DRAWING NO. D206-540	REV. 1 SHEET 7 OF 8
CHECKED	APPROVED	TITLE UTILITY BASKET INSTALLATION	SCALE NTS
DATE 05.11.10			

DART

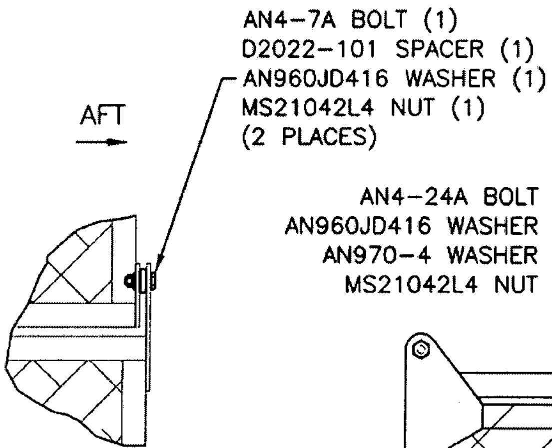
DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D206-540 — REV. I — SHEET 8 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION — SCALE NTS



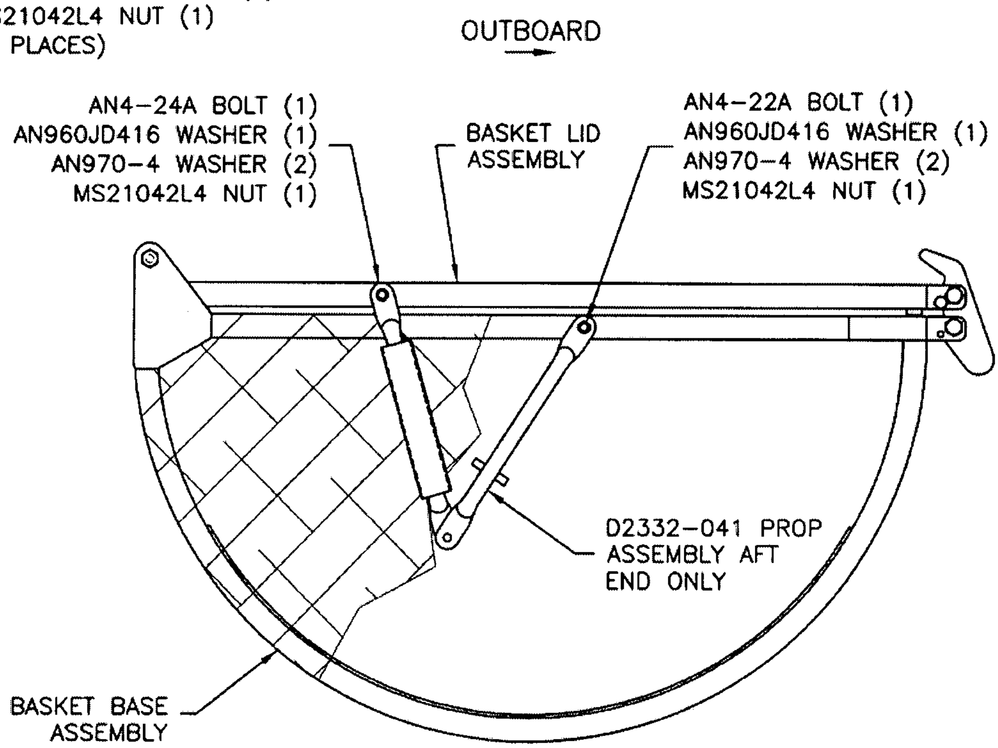
LATCH DETAIL



SPRING DETAIL



HINGE DETAIL
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE



PROP ARM & HINGE DETAIL
END VIEW, LOOKING AFT
OTHER END OPPOSITE

Dart Aerospace Ltd.

Date: Thursday, 05/06/2008 1:54:15 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 206B BASKET LID - UNDER REVIEW
Job Number	: 39733A		
Estimate Number	: 11280		
P.O. Number	:	**Part Number**	: D2330043
This Issue	: 05/06/2008 **S.O. No.** :	**Drawing Number**	: D2330 REVE
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : LARGE FAB ASSY	**Drawing Revision**	: E
Previous Run	: 34669A	**Material**	:
Written By	: ____________	**Due Date**	: 12/06/2008 **Qty:** 1 **Um:** Each
Checked & Approved By	: ____________		
Comment	: Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

✓

Comment: Qty.: 23.3625 f(s)/Unit Total : 23.3625 f(s)
3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M108063 M108153 (6.99) SAD 08/06/09 ①

Seq. #:	Machine Or Operation:	Description :
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2330-1-3-9 as per Dwg D2330 SAD 08/06/09 ①

2-Drill hole in D2330-3 as per Dwg D2330

3-Deburr

Seq. #:	Machine Or Operation:	Description :
3.0	D22321	Basket Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-1	HINGE	B35684

✓ FC 08 06 10

Seq. #:	Machine Or Operation:	Description :
4.0	D2329	Label Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2329	Label Plate	B35686

✓ FC 08 06 10

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 1:54:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 206B BASKET LID - UNDER REVIEW

Job Number: 39733A
Part Number: D2330043

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D23271	Spacer Bushing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2327-1 Bushing D36920 ✓ FC 08 06 10

6.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2581 Mounting Chanel D34046 ✓ FC 08 06 10

7.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)
Pick:
Qty Part Number Description Batch
18 sf M304EX0.75-16F Expanded Metal M107856 SAD 08/06/09

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig
Deburr as required
A/R SS ROD Batch: M107051 FC 08 06 10

9.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION PD 08-06-10

10.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 08/06/11

POSITIVE RECALL

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 1:54:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** 206B BASKET LID - UNDER REVIEW

Job Number: 39733A | **Part Number:** D2330043

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	POWDER COATING	POWDER COATING

M107925 (1X)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 10:00 °F
OVEN TEMPERATURE: 400
FINISH TIME: 10:30

2nd coat Start Time: 10:45
oven Temp: 400 °F
Finish Time: 11:15
08/06/11

12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 08-06-11 (X1)

13.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA 08/06/11 (1)

14.0	QC21	FINAL INSPECTION/W/O RELEASE

08/06/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

08-06-12

POSITIVE RECALL
EFFECTIVE 08-06-08 AUTH
RELEASED DATE

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	MB	
CHECKED	APPROVED	DRAWING NO. D2330 — REV. E — SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B) — SCALE NTS

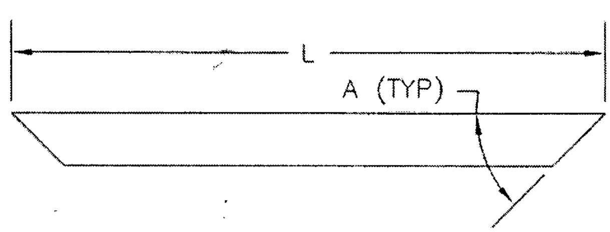
DART

REV	DATE	DESCRIPTION
C	96.05.23	ADDED LATCH AND LABEL PLATE
D	99.09.14	MODIFIED LATCH, REDREW
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11

Qty -041	Qty -043	Part Number	Description	L	A
X		**D2330-041**	**BASKET ASSEMBLY**		
	X	**D2330-043**	**LID ASSEMBLY**		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
	2	D2330-11	FRAME	83.27	45
	2	D2330-13	FRAME	23.63	90
	1	D2330-15	FRAME	33.00	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

w/o 39733A

NOTES:
1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE (REF. DART SPEC. M304TS0.075W.0.60)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

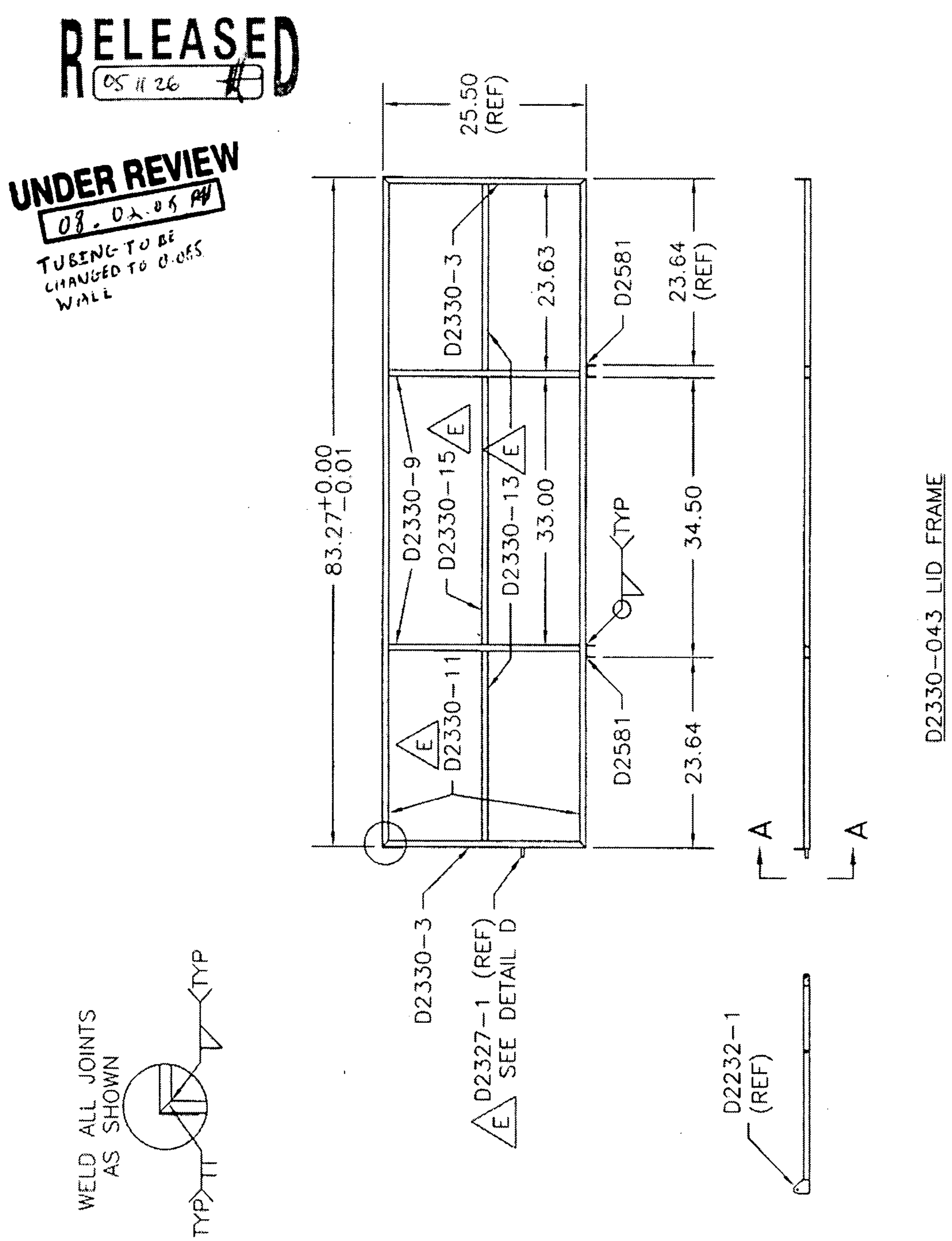


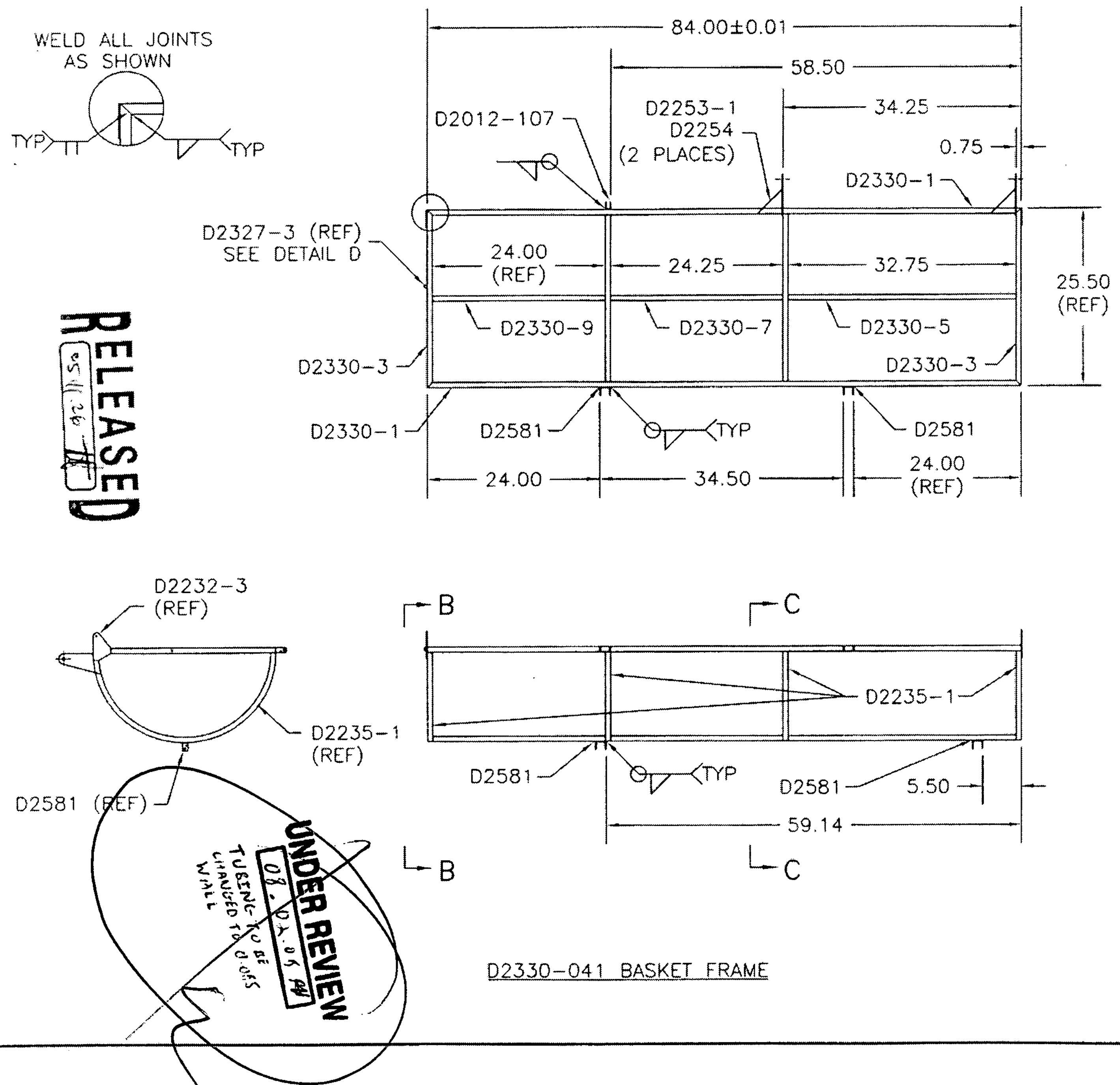
CUT SIZE DETAIL

UNDER REVIEW 08.02.05
TUBING TO BE CHANGED TO 0.065 WALL

RELEASED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
KE	MB		
CHECKED	APPROVED	DRAWING NO. D2330	REV. E SHEET 2 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS

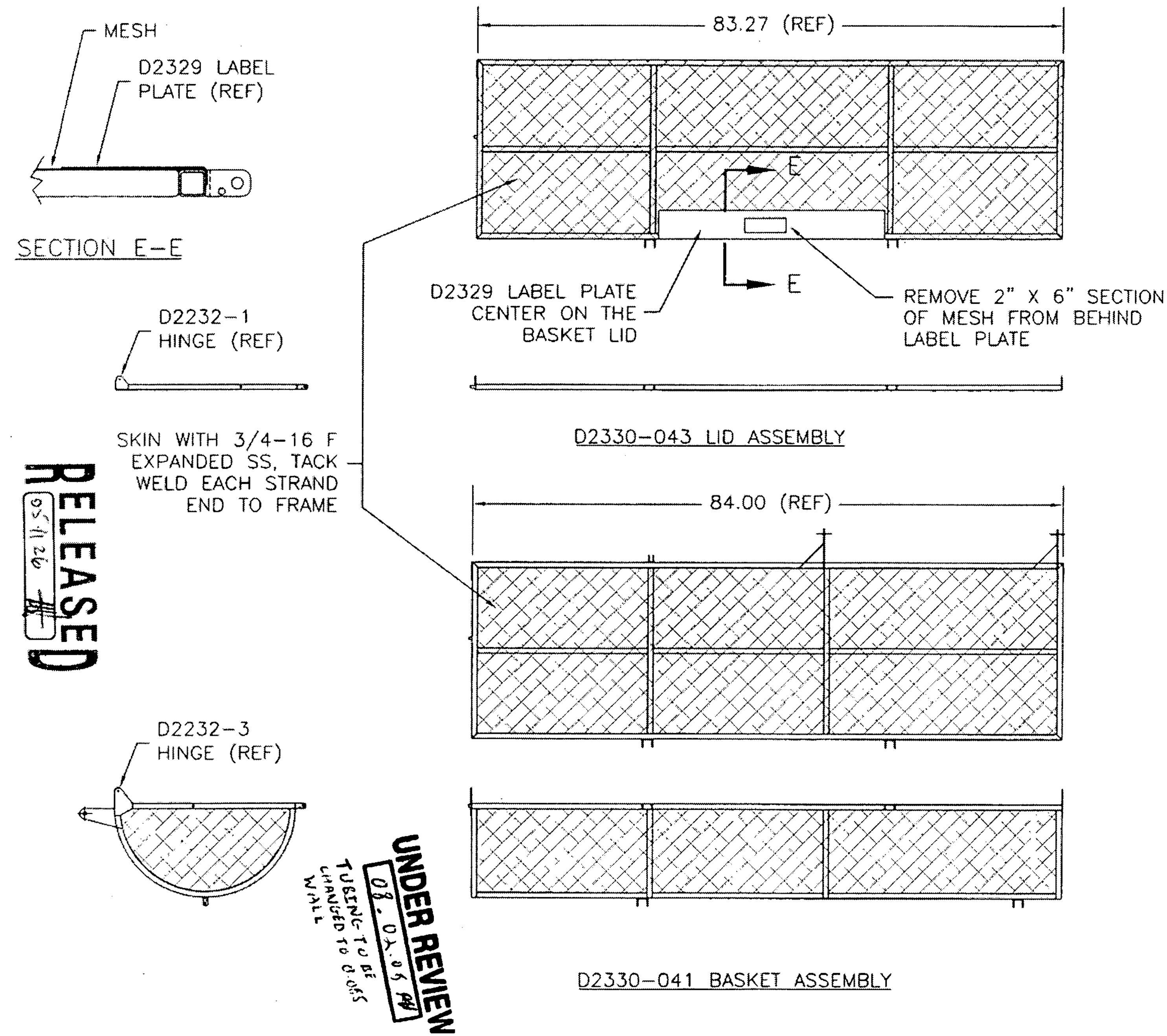




D2330-041 BASKET FRAME

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	MB	
CHECKED	APPROVED	DRAWING NO. D2330 — REV. E — SHEET 3 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B) — SCALE NTS



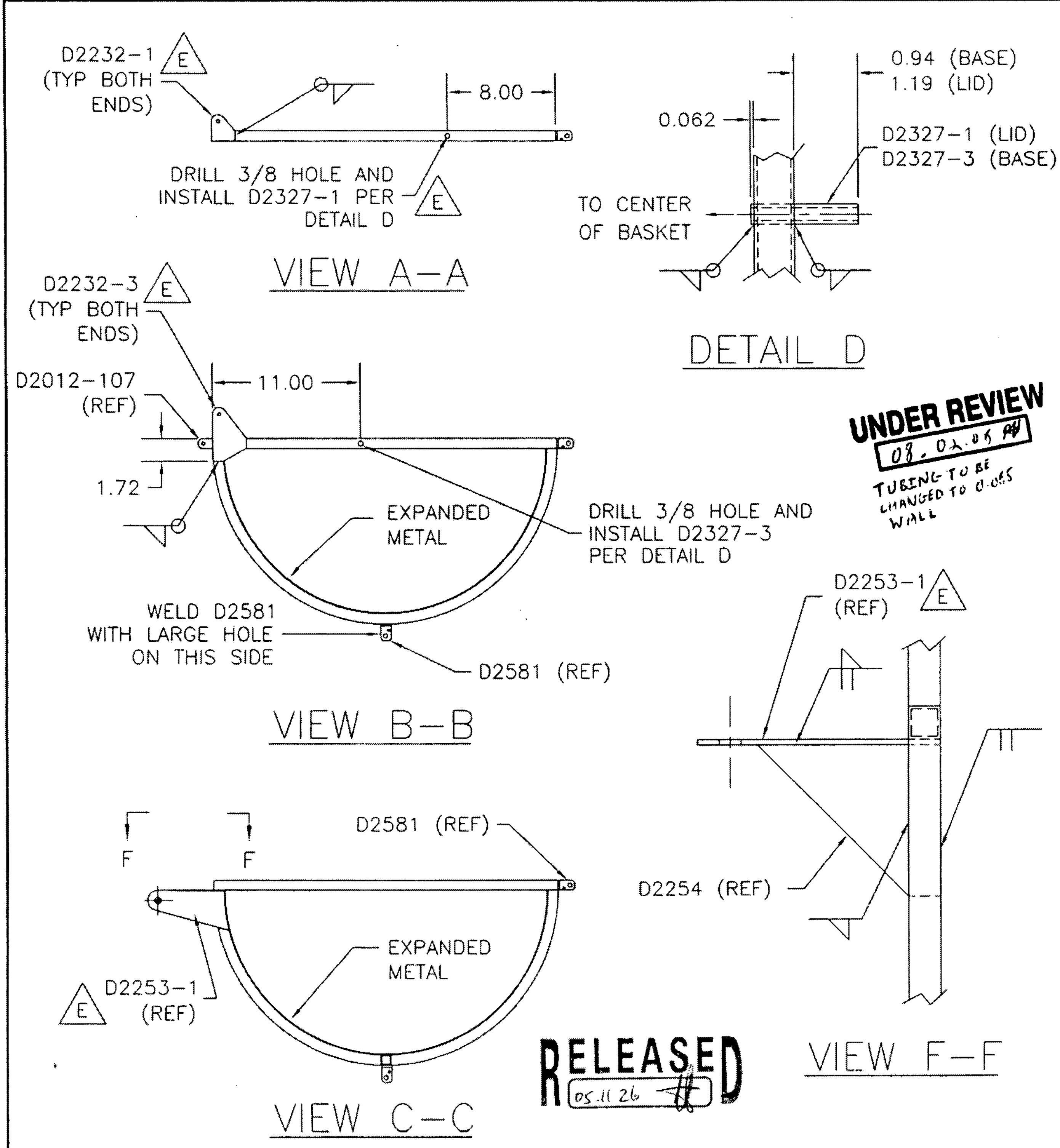
DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV.
KE	MB	D2330	E
CHECKED	APPROVED	TITLE	SHEET 4 OF 5
DATE 05.11.10		BASKET ASSEMBLY (206B)	SCALE NTS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	MB	
CHECKED	APPROVED	DRAWING NO. D2330 — REV. E — SHEET 5 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B) — SCALE NTS

DART



Dart Aerospace Ltd.

Date: Thursday, 05/06/2008 1:54:25 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 39733B
Estimate Number : 11276
P.O. Number :
This Issue : 05/06/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / /
Type : LARGE FAB ASSY
Previous Run : 34669B
Written By :
Checked & Approved By :
Comment : Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J

Drawing Name : 206B BASKET BASE - UNDER REVIEW
Part Number : D2330041
Drawing Number : D2330 REVE
Project Number : N/A
Drawing Revision : E
Material :
Due Date : 12/06/2008 Qty: 1 Um: Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part#	Description	Batch
4	D3166-1	Hoop	B39443 ✓

POSITIVE RECALL

Cpl 08.06.09

Seq. #:	Machine Or Operation:	Description :
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

✓

Comment: Qty.: 25.3019 f(s)/Unit Total : 25.3019 f(s)
3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M108063

M108153 (7') SAD 08/06/09 (R)

Seq. #:	Machine Or Operation:	Description :
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.
Cut 4 D2235-1 From D3166-1

2- Cut D2330-1-3-5-7-9 as per Dwg D2330

3-Drill hole in D2330-3 as per Dwg D2330

4-Deburr

SAD 08/06/09 — (R)

Cpl 08.06.09

Seq. #:	Machine Or Operation:	Description :
4.0	D22531	Lug

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Gusset
Batch: B35685 ✓

Cpl 08-06-09

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 1:54:25 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206B BASKET BASE - UNDER REVIEW

Job Number: 39733B **Part Number:** D2330041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D2012107	Clevis

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2012-107 Clevis ~~[illegible]~~ B33585✓ PPC 08-06-09

6.0	D23273	Spacer Bushing

PR

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2 ~~1~~.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2327-3 Bushing B37541✓ PPC 08·06·09

7.0	D2581	Mounting Bracket

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:
Qty Part Number Description Batch
4 D2581 Mounting Chanel B39046✓ PPC 08·06·09

8.0	D2254	Gussett

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2254 Lug B23421✓ PPC 08·06·09

9.0	D22323	Basket Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2232-3 HINGE B36846✓ PPC 08·06·09

10.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 31.5000 sf(s)/Unit Total : 31.5000 sf(s)
Pick:
Qty Part Number Description Batch
30 sf M304EX0.75-16F Expanded Metal M107966✓ SAD 08/06/09 ①
M108152✓

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2330-041 PAR #: N/A Fault Category: Prod / Fab Large NCR: Yes No DQA: D Date: 08/06/12

QA: N/C Closed: [signature] Date: 08/06/13

NCR: 39733B	WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
8/6/9	2 6.0	During welding the welder welded an extra D2327-3 Bushing. only calls for 1.	[initial] 080612	Remove extra Bushing and Grind Flush Qty x2 Plug holes with weld AS per QSI 004	[initial] 080610 [initial] 080610	[initial] 080611	[initial] 080612	[initial] 08/06/09
		R.C Lack of attention monday morning @ 28.2°C and 65% Humidity.	[initial] 080612				[initial] 080612	[initial] 08/06/09

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Thursday, 05/06/2008 1:54:25 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 206B BASKET BASE - UNDER REVIEW

Job Number: 39733B
Part Number: D2330041

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner JigDeburr as required
A/R SS ROD Batch: M106762

Cd 08·06·10

Seq. #:	Machine Or Operation:	Description :
12.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION PD 08-06-10

Seq. #:	Machine Or Operation:	Description :
13.0	QC5	INSPECT WORK TO CURRENT STEP

POSITIVE RECALL

Comment: INSPECT WORK TO CURRENT STEP S 08/06/11

Seq. #:	Machine Or Operation:	Description :
14.0	POWDER COATING	POWDER COATING

M107925 (1X)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:00 of
OVEN TEMPERATURE: 400
FINISH TIME: 11:30

2nd Coat
Start Time: 11:45 OE
Oven Temp: 400 15
Finishing Time: 12
M.K. 08/06/11

Seq. #:	Machine Or Operation:	Description :
15.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 08-06-11 (x1)

Seq. #:	Machine Or Operation:	Description :
16.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: G-A

SB 08/06/11 (1)

Seq. #:	Machine Or Operation:	Description :
17.0	QC21	FINAL INSPECTION/W/O RELEASE

08/06/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

08-06-12

POSITIVE RECALL
EFFECTIVE 08·06·09 AUTH
RELEASED ____ DATE 08/06/11

Form: rprocess

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	MB	
CHECKED	APPROVED	DRAWING NO. D2330 — REV. E — SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B) — SCALE NTS

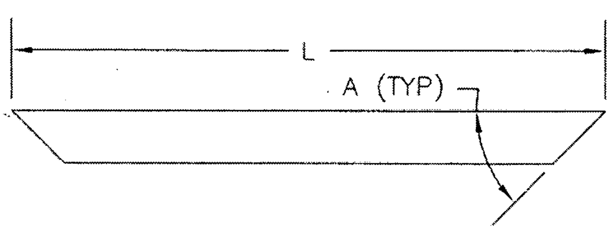
REV	DATE	DESCRIPTION
C	96.05.23	ADDED LATCH AND LABEL PLATE
D	99.09.14	MODIFIED LATCH, REDREW
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11

Qty -041	Qty -043	Part Number	Description	L	A
X		**D2330-041**	**BASKET ASSEMBLY**		
	X	**D2330-043**	**LID ASSEMBLY**		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
	2	D2330-11	FRAME	83.27	45
	2	D2330-13	FRAME	23.63	90
	1	D2330-15	FRAME	33.00	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

W039733B

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE (REF. DART SPEC. M304TS0.075W.0.60)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

UNDER REVIEW 08.02.05 TUBING TO BE CHANGED TO 0.065 WALL

RELEASED 05.11.26

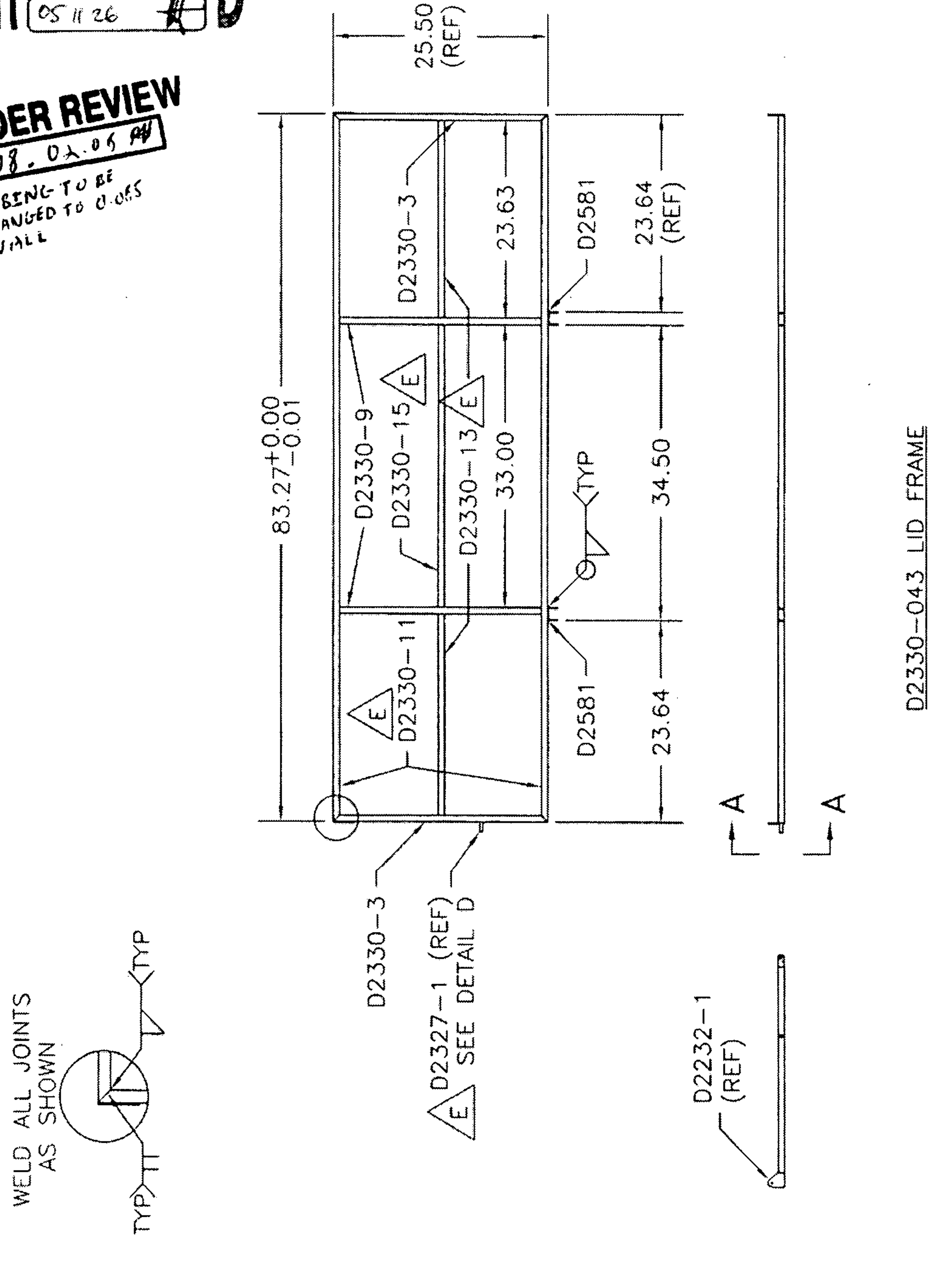
DART

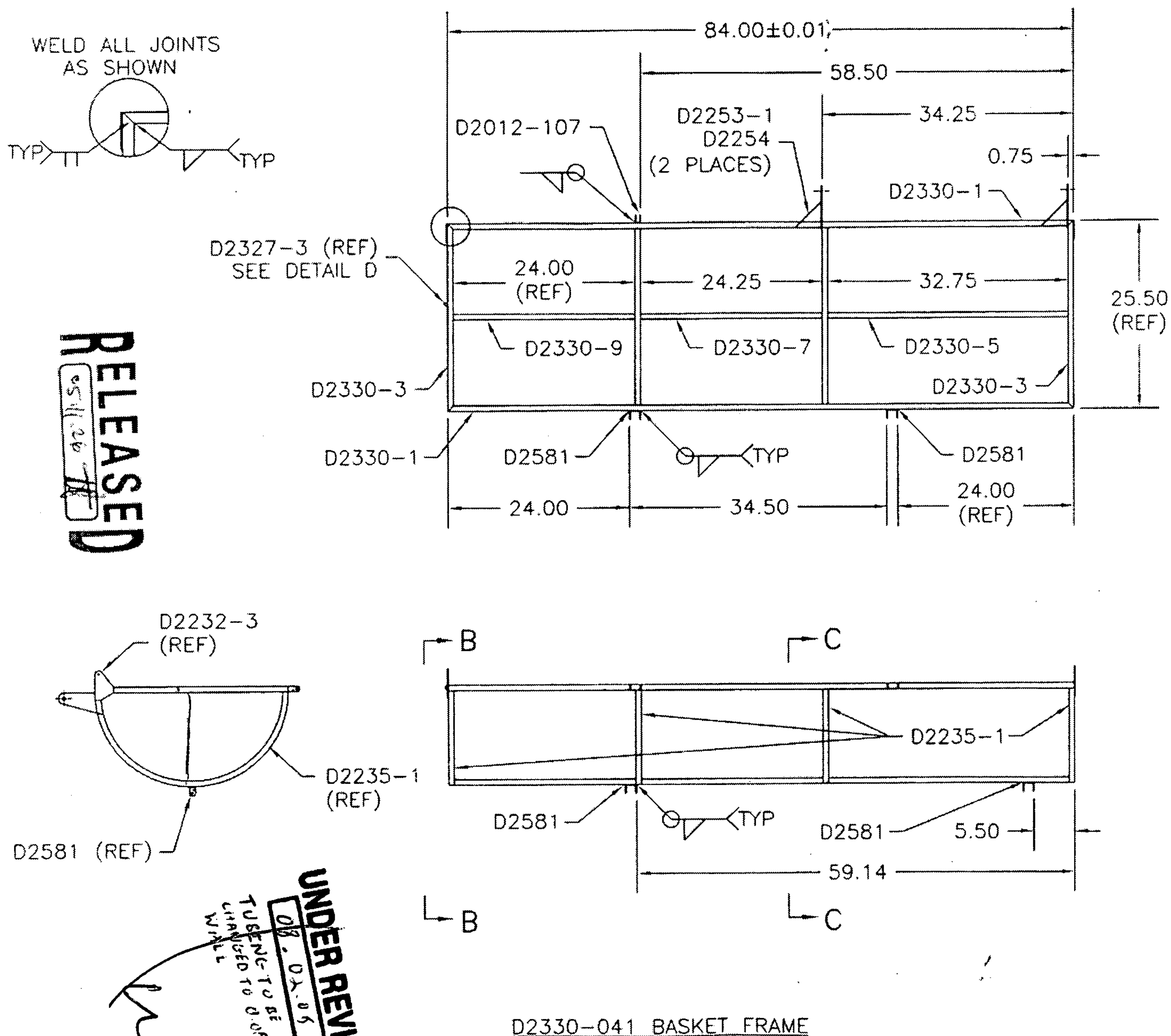
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KE	MB	
CHECKED	APPROVED	DRAWING NO. D2330 REV. E SHEET 2 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B) SCALE NTS

RELEASED 05 11 26

UNDER REVIEW 08.02.05

TUBING TO BE CHANGED TO 0.065 WALL





D2330-041 BASKET FRAME

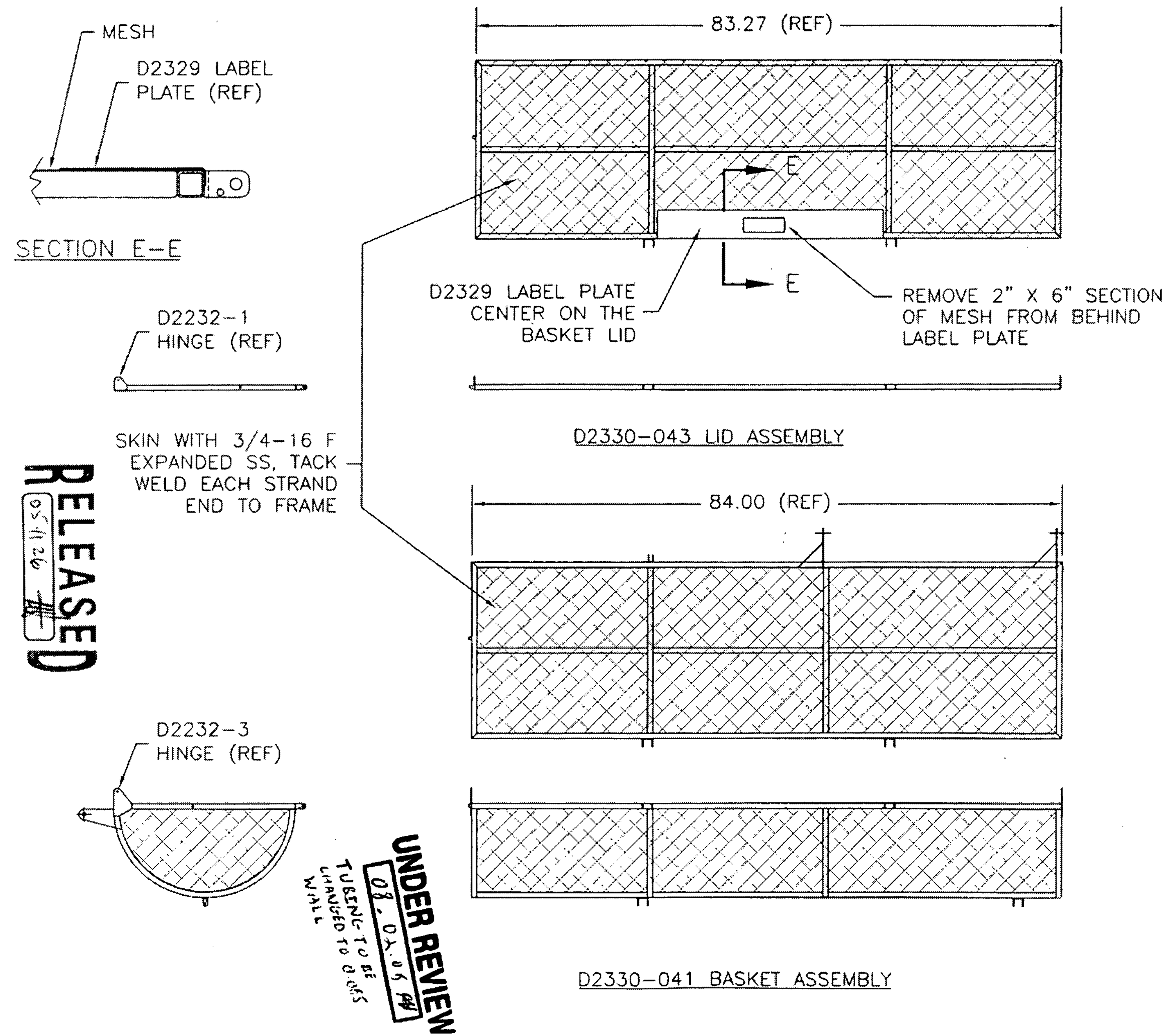
RELEASED 05.11.26

UNDER REVIEW 08.02.06

TUBING TO BE CHANGED TO 0.065 WALL

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	MB	
CHECKED	APPROVED	DRAWING NO. D2330 — REV. E
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)
		SHEET 3 OF 5 — SCALE NTS



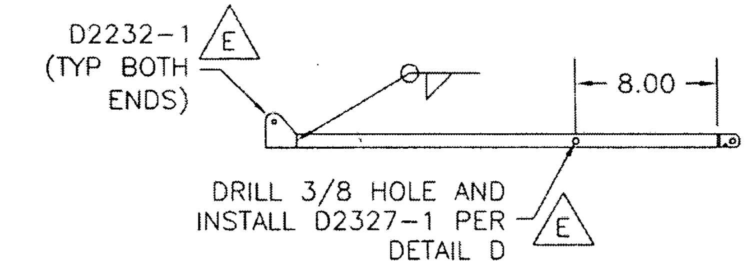
DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

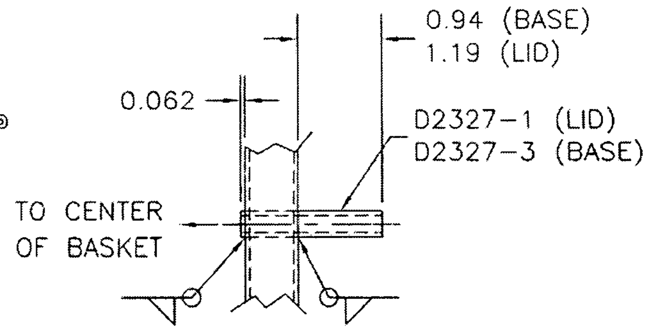
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KE	MB	D2330	E
CHECKED	APPROVED	SHEET 4 OF 5	
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS

DART

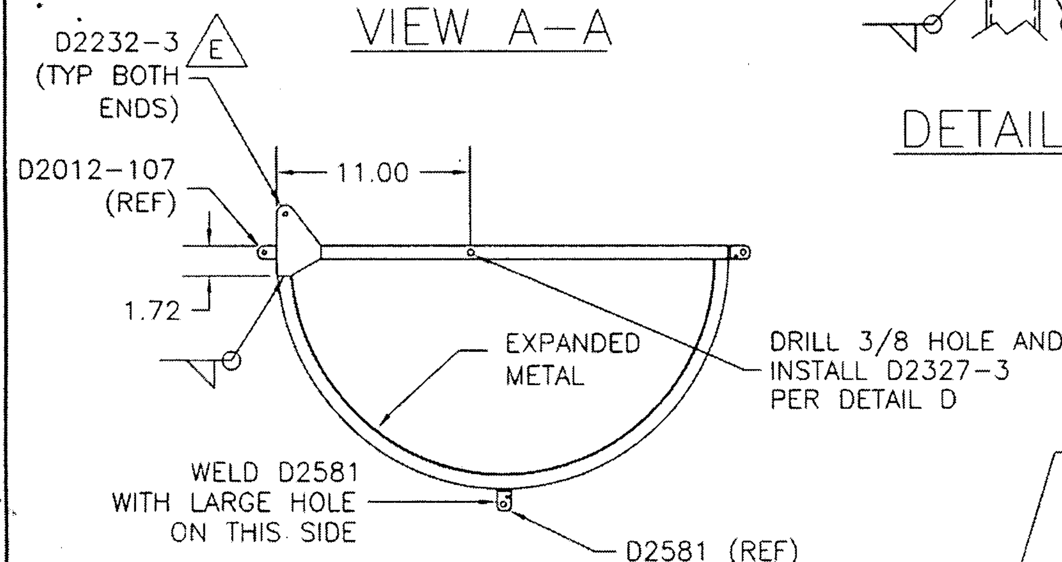
DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2330	REV. E SHEET 5 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS



VIEW A-A



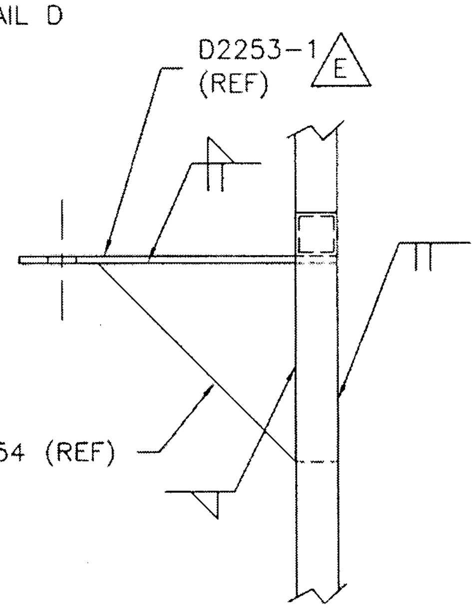
DETAIL D

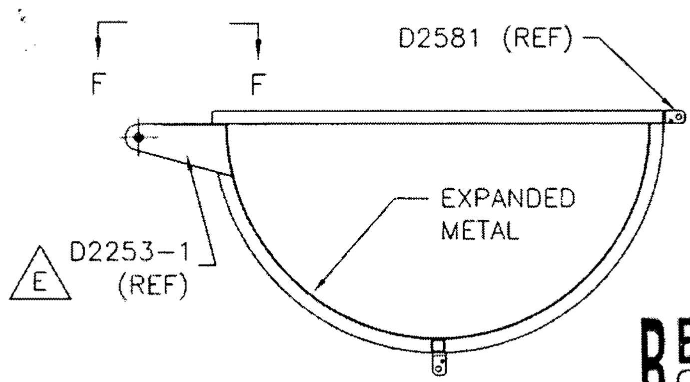


VIEW B-B

UNDER REVIEW 08.02.06

TUBING TO BE CHANGED TO 0.065 WALL





VIEW C-C

RELEASED 05.11.26

VIEW F-F